

PRODUCT BULLETIN
GYPSUM PRODUCTS

BOARD PRODUCTS
ALUMINUM FOIL BACKED
GYPSUMBOARD OR LATH

BULLETIN NO: B-G-10
DATE: 2/5/73
PAGE: 1 of 3

APPROVALS:

CANCELS: B-G-10
DATE: 6/10/69

This Bulletin covers material requirements, lamination methods and finished product specifications for aluminum foil backed board or lath products.

Do NOT apply foil to water-resistant core treated gypsumboard products.

PRODUCING PLANTS: Long Beach, Antioch, Seattle, Jacksonville

MATERIALS

1. Aluminum Foil, paper backed See Bulletin RM-B-16

Aluminum foil shall be purchased in rolls cut to proper widths within $\pm 1/16"$ of board or lath to which it is intended for laminating.

2. Foil Adhesive, Type B See Bulletin RM-B4

3. a. Gypsum Wallboard - used for lamination of aluminum foil includes

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3/8" Regular Wallboard	B-2
1/2" Regular Wallboard	B-3
1/2" Type X Super Null-A-Fire Wallboard	B-4
5/8" Regular Wallboard	B-5
5/8" Null-A-Fire, Type X Wallboard	B-6
3/8" Backerboard	B-7
1/2" Acoustibak (or long lath)	B-8
1/2" Acoustibak, Type X	B-8A
5/8" Acoustibak (or lath) Type X	B-9

- b. Gypsum Lath - used for lamination of aluminum foil includes:

Plain Lath	B-14
3/8" Duralath Type X	B-14A
1/2" Plain Lath	B-15
1/2" Type X Super Duralath	B-15A

- c. Gypsum Veneer Base - used for lamination of aluminum foil includes:

1/2" Regular Gypsum Veneer Base	B-15B
1/2" Type X Super Gypsum Veneer Base	B-15D
5/8" Type X Gypsum Veneer Base	B-15C

Gypsum Wallboard, Lath, and Veneer Base used for aluminum foil lamination shall meet all product specifications as listed in the appropriate Operating Bulletins, except as noted:

- a. Talc - Do not apply talc or soapstone to the back of board to be used for foil lamination.

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MATERIALS: (CONTINUED)

- b. Moisture at Take-Off - 14" Maximum
- c. Bundling - Gypsum Wallboard and Veneer Base may be laminated in bundles. Gypsum lath should not be bundled prior to foil lamination.
- d. Back Paper Ply Separation - Ply bond of back paper shall be such that maximum end ply separation is less than 1/2".

LAMINATION:

1. Roll of aluminum foil shall be positioned on the laminator so one edge of the foil will line up with the edge of the gypsum board or lath to within $\pm 1/16$ " and with the foil side up as applied onto the gypsum board.
2. Adhesive shall be applied across the full width of the aluminum foil at minimum thickness consistent with proper bond development. (Too much adhesive will lengthen time needed for bond development.)
3. Precautions shall be taken to prevent contamination of adhesive during lamination.
4. Viscosity of the foil adhesive shall be tested for conformance to use requirements. Screen adhesive through cheesecloth prior to pouring into laminator adhesive feed-through, if it is old, appears lumpy or has a surface skim in the storage pail.
5. Each bundle of board or veneer base (or each piece of lath) fed to the laminator shall be inspected for damage to edges, ends or corners. Damaged board shall not be fed to the laminator.
6. The surface of the board, base or lath shall be cleaned prior to entry into the laminator.
7. Each bundle or piece shall be butted endwise with a space to leave a 1/16" gap and shall be firmly held in precise linear alignment as fed to the laminator.
8. Aluminum foil coated with the proper film or adhesive applied shall be laminated to the board, lath or base with sufficient pressure, smoothing and brushing to form complete contact and to exclude all air pockets between the board face and the aluminum foil.
9. Aluminum foil shall be carefully cut between the ends of the board, lath or base with a knife. All loosely bonded areas of aluminum foil on ends and edges shall be hand smoothed prior to stacking (or bundling). Aluminum foil may be $\pm 1/8$ " on each end.

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LAMINATION: (CONTINUED)

10. Bundled board or veneer base with aluminum foil laminated onto one board shall be inverted and refed through the laminator to apply aluminum foil onto the other piece in the bundle.

FINISHED PRODUCT SPECIFICATIONS:

Refer to individual Product Bulletins for gypsum board, lath and veneer base dimensional tolerances including length, width, diagonal measurements, profile, etc.

Aluminum Foil Lamination

1. Widths - Aluminum foil shall extend to within 1/8" of each edge.
2. Surface - Aluminum foil shall be smooth, free from wrinkles and "blisters".